

Date: Friday, 01/08/2008 3:31:12 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FRONT LEG FITTING ASS'Y			
Job Number	: 40947						
Estimate Number	: 13342						
P.O. Number	:			Part Number	: D3762041		
This Issue	: 01/08/2008	S.O. No.			Drawing Number	: D3762 REVA	
Prsh Rev.	: NC				Project Number	: N/A	
First Issue	: / /		Type	: LARGE FAB ASSY			
Previous Run	: 40946			Drawing Revision	: A		
Written By	:			Material	:		
Checked & Approved By	: <u>JUL 08.8.05</u>			Due Date	: 21/08/2008		
Comment	: Est Rev:A 08-05-20 new issue DD verified by:ec			Qty:	8		
	Est Rev:B 08-06-17 rev.A as per dwg DD verified:EC			Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Pick Packing Kit		
2.0	D37621	Fitting
Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) Fitting batch: <u>B41007</u> ✓ <u>SP 08.08.19</u> <u>16x</u>		
3.0	D37623	Tube
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Tube batch: <u>B41008</u> ✓ <u>SP 08.08.19</u> <u>8x</u>		
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1-assemble as per dwg D3762 using locating pins DT9014 and tack weld parts in place 2- take pins out before welding 3-weld as per dwg D3762 per QSI004 Alum. rod Batch: <u>H108037</u> <u>SP 08.08.19</u> <u>8x</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 3:31:12 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT LEG FITTING ASS'Y

Job Number: 40947

Part Number: D3762041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-08-20 (8)

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/20 (8)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08/08/20

(8)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/08/20

(8)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ~~ST~~ ST

mf 08-08-21

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

mf 08-08-21

Job Completion



mf 08-08-21

Dart Aerospace Ltd

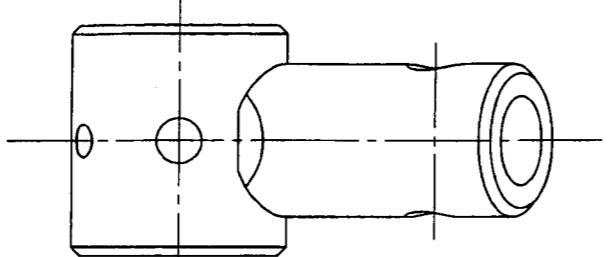
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

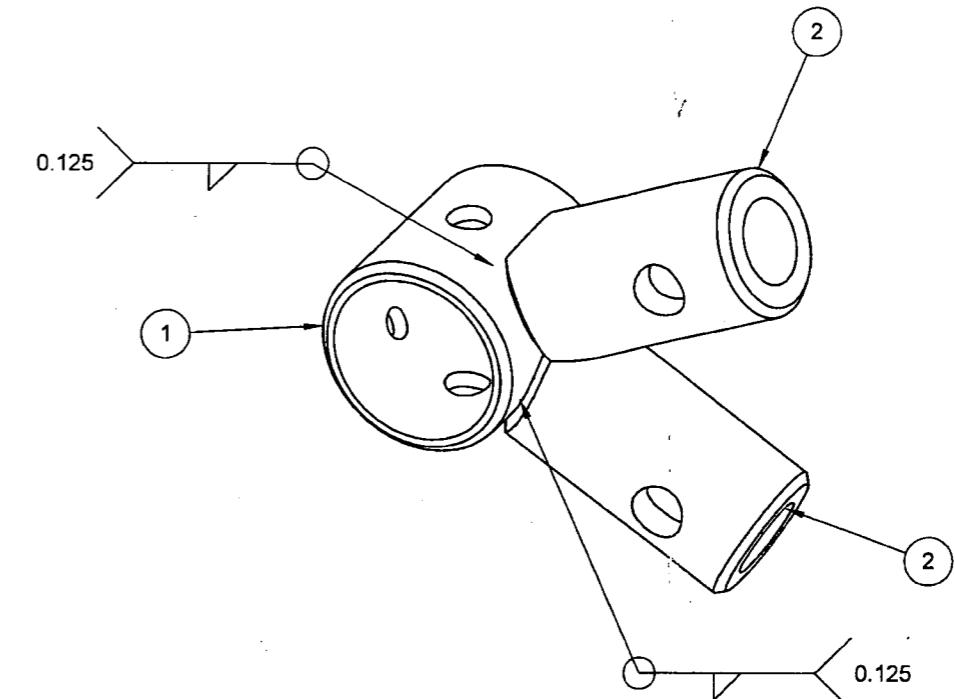
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



The technical drawing illustrates a flange assembly. It features a central circular hole with a diameter of 1.605 inches. Two rectangular flanges extend from the top and bottom of the central hole. Each flange has a thickness of 1.605 inches. A note specifies that the welds between the flanges and the central plate are acceptable to remove to allow for the installation of a NAS1149F0363P washer on both sides. The flanges are inclined at an angle of 54° relative to the horizontal centerline.



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3762-3	TUBE	1
2	D3762-1	FITTING	2

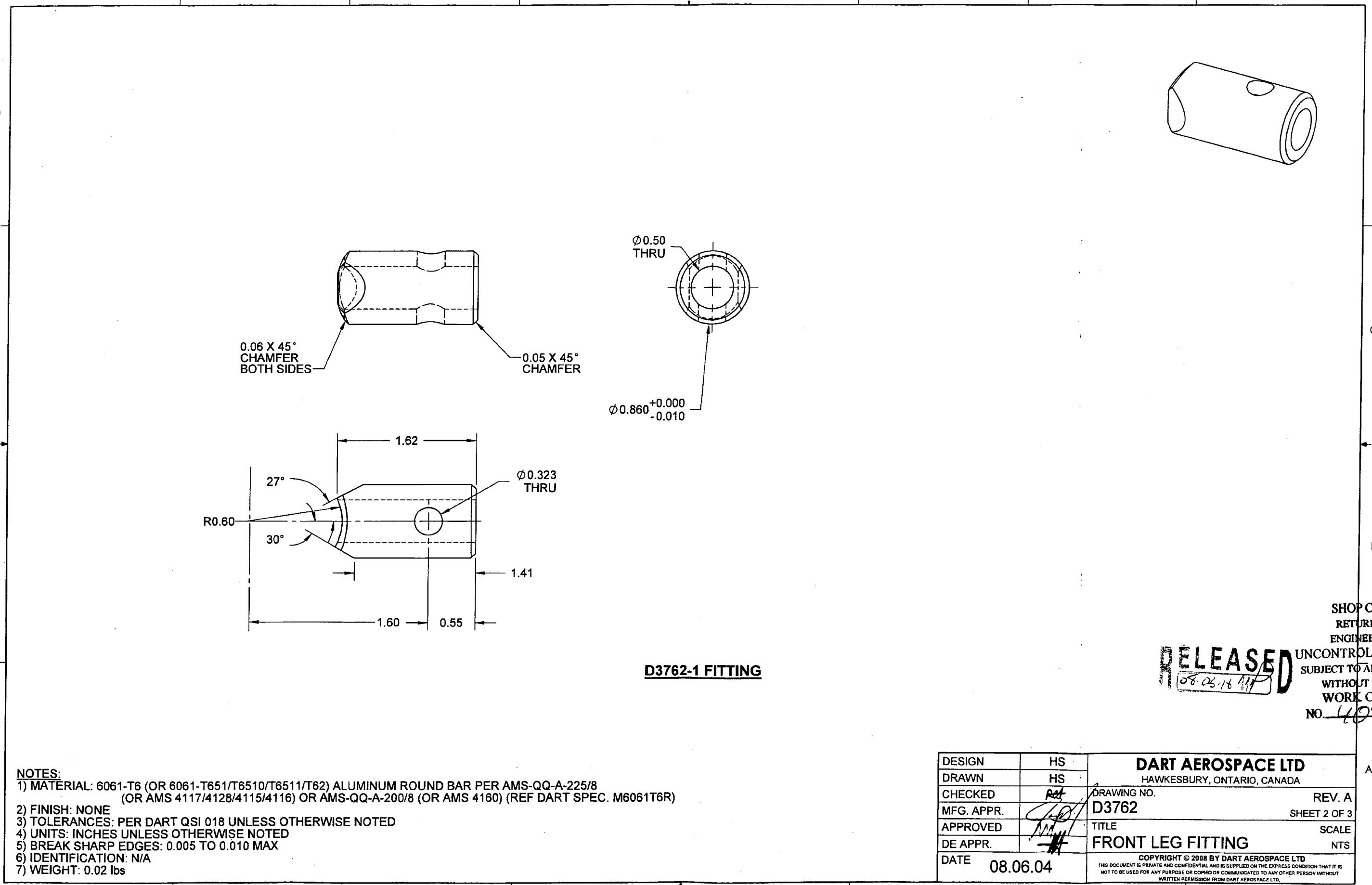
SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 110947

D3762-041 FRONT LEG FITTING ASSY

NOTES:

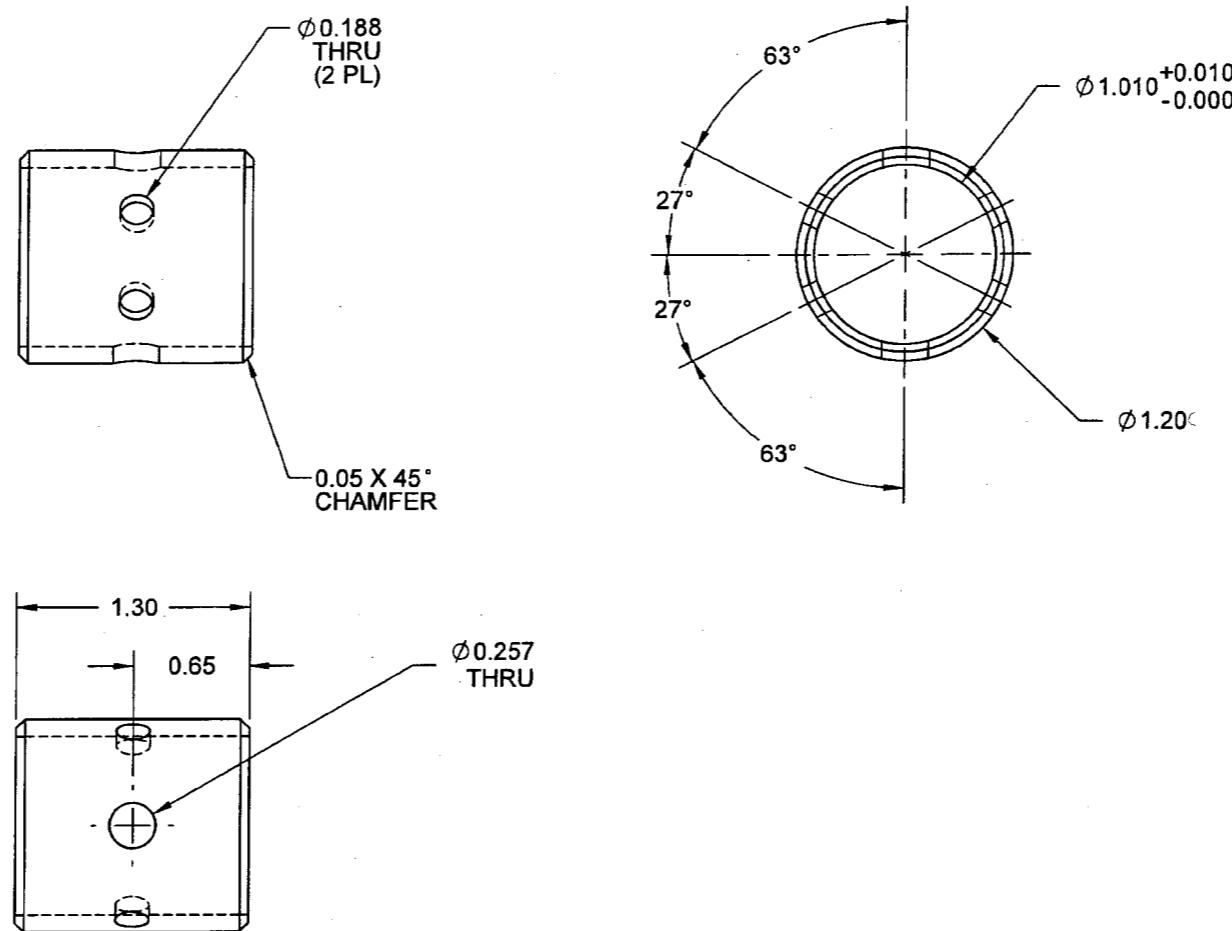
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) WELD: PER DART QSI 004

A	NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD		
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>PJ</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>AS</i>	D3762	SHEET 1 OF 3	
APPROVED	<i>MW</i>	TITLE	SCALE	
DE APPR.	<i>AS</i>	FRONT LEG FITTING	NTS	
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		



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D3762-3 TUBE

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WITHOUT NOTICE
WORK ORDER
NO. 40977

- NOTES:
 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8
 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6R)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.01 lbs

DESIGN	HS	DART AEROSPACE LTD			
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA			
CHECKED	RE	DRAWING NO.			
MFG. APPR.	AD	D3762	REV. A		
APPROVED	JW	TITLE			
DE APPR.	SH	SCALE			
DATE	08.06.04	FRONT LEG FITTING			
NTS					
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